

Split

Work Order ID 74301-1

Wednesday, September 28, 2011 10:46:22 A



Page 1

Item ID: D4092-041

Revision ID: ~~041~~ 041.639

Item Name: Maintenance Step Assembly

Start Date: 9/28/2011 Start Qty: 5.00

Required Date: 10/14/2011 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4092

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg
Torque screws up to 15-25 in- lbs

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



10/10/14

SP 11/10/14

(2)

*to be 13 Day only
8/11/14*

(2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74301

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Page 2

Item ID: D4092-041

Accept



Setup Start



Revision ID: U/R

Item Name: Maintenance Step Assembly

Stop



Start Date: 9/28/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

PPC
74202

0.00

11/12/14 (2)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/10/13

MF

11-10-14

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 10:46:18 AM

Page 1

Work Order ID: 74301

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly



Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD IPP
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 		Manufactured	No			100	Each	0.0000	2	10			
Maintenance Step										74303			
D4093-1 		Manufactured	No			100	Each	0.0000	1	5			
Bracket										74305			
D4093-3 		Manufactured	No			100	Each	0.0000	1	5			
Bracket										74306			
D4093-5 		Manufactured	No			100	Each	6.0000	2	10			
Bracket										74307			

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MS24694-S54 	Purchased	No	ST124	6	
Screw			62569	6	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST289	100	
118078	100	
ST289A	48	
117677	48	

117679

[Handwritten signature] 11/10/11 (5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, September 28, 2011 10:46:19 AM

Page 2

Work Order ID: 74301

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

MS24694-S55

Purchased

No

100

Each

61.0000

8

40



Screw

19

Location

Loc Qty

Loc Code

ST289A

61

13884

61

MS24694-S56

Purchased

No

100

Each

56.0000

2

10



SCREW

Location

Loc Qty

Loc Code

ST289A

56

104407

56

NAS1149D0332J

Purchased

No

100

Each

2,907.000

12

60



Washer

Location

Loc Qty

Loc Code

ST297

869

117087

869

ST298

1038

105793

12

118078

26

118384

1000

ST302

1000

119042

1000

13884 21x

104407 60

117087

10/14/14

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Wednesday, September 28, 2011 10:46:19 AM

Page 3

Work Order ID: 74301

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly



Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

100

Each

8,399.000

12

60



Nut

Location

Loc Qty

Loc Code

ST300

2399

117441

16

117601

240

117885

143

118451

1000

118927

1000

118927

ST516

6000

119017

6000

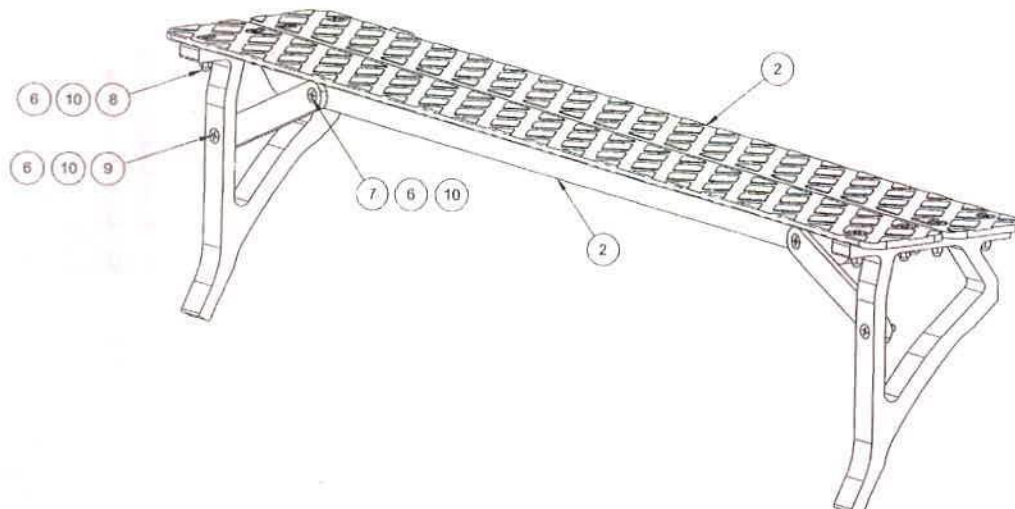
Dart Aerospace Ltd

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D4092-041 MAINTENANCE STEP ASSEMBLY



W/O 74301

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1140D0332J	WASHER

RELEASED
2011-09-22

B	REDRAWN, LOWERED FOR AESTHETICS	RF	11.07.2F
A	NEW ISSUE	RF	10.09.1E
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>AP</i>		
MFG. APPR.	<i>AP</i>		
APPROVED	<i>AP</i>		
DE APPR.	<i>AP</i>		
DATE	11.07.27		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D4092** REV. **B**
SHEET 1 OF 6
TITLE **MAINTENANCE STEP ASSY** SCALE **NTS**

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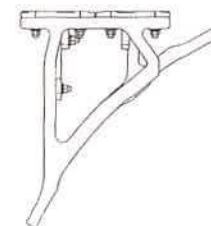
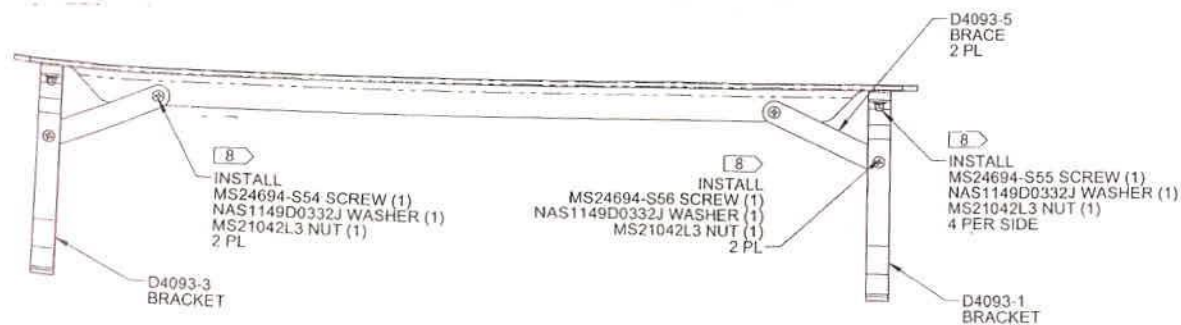
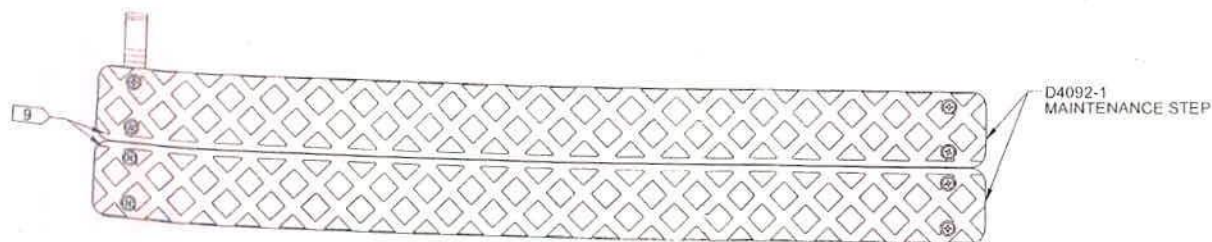
Dart Aerospace Ltd

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	9/1	D4092	SHEET 3 OF 11
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASSY	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

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